

Date: Tuesday, 3/20/2007 2:36:02 PM
User: Kim Johnston

Process Sheet

58117

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 31386 -2	
Estimate Number : 10032	
P.O. Number : N/A	Part Number : D6101001
This Issue : 3/20/2007 S.O. No. : N/A	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 25345	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 6/1/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 120 Um: Each
Comment : Est. B: 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3385

C207103122

a) Description: Alluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.025"/-0.000" E+/-0.008"

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

(120) 60

2.0	D6101001P	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 120.0000 Each(s)
7075-T7351 2X6X6.25

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C207108123 (60)

~~C207108123 (60)~~

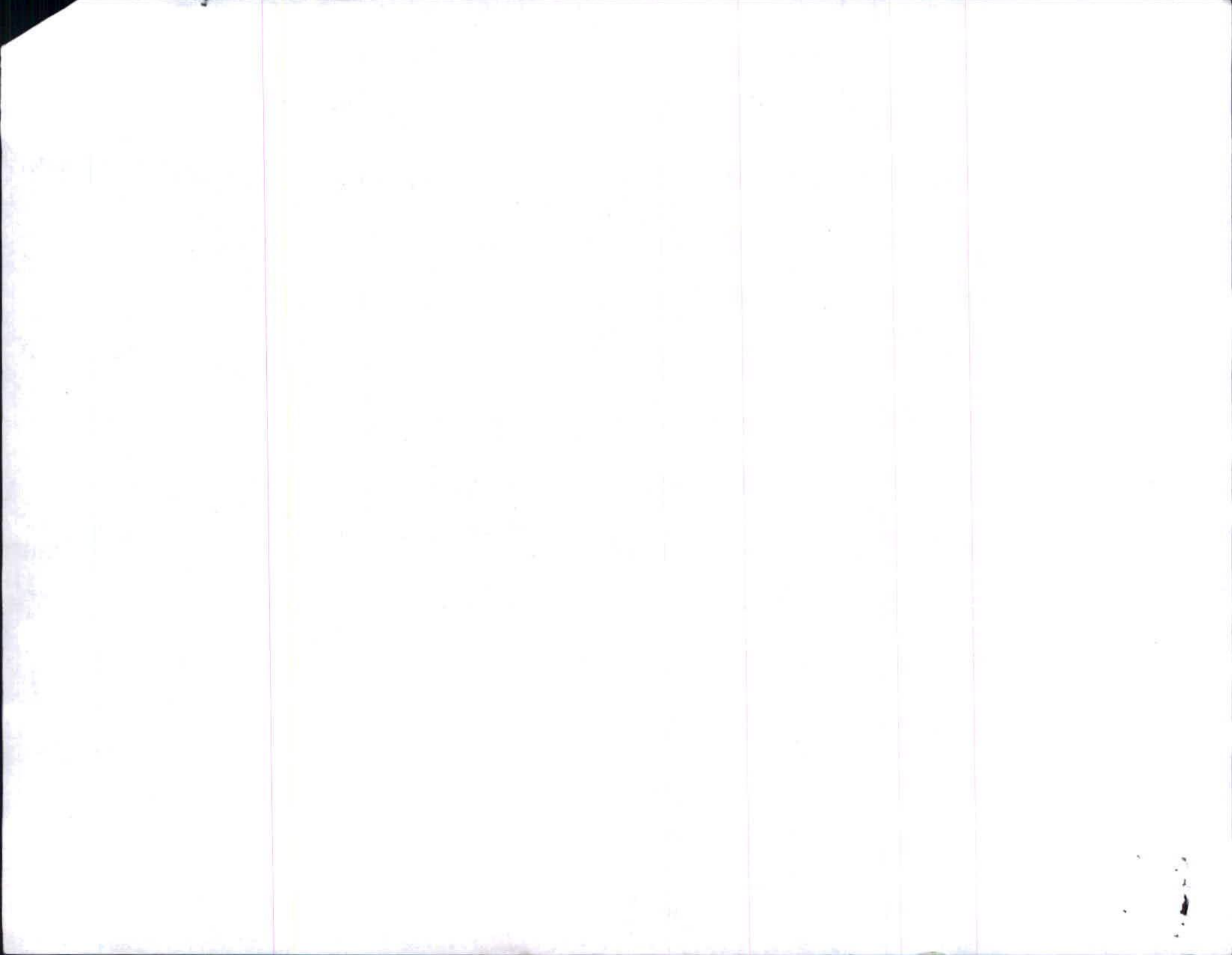
4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D

J.L 07108/24



Date: Tuesday, 3/20/2007 2:36:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 31386

Part Number: D6101001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C207/08/24

(60)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/08/27

Job Completion



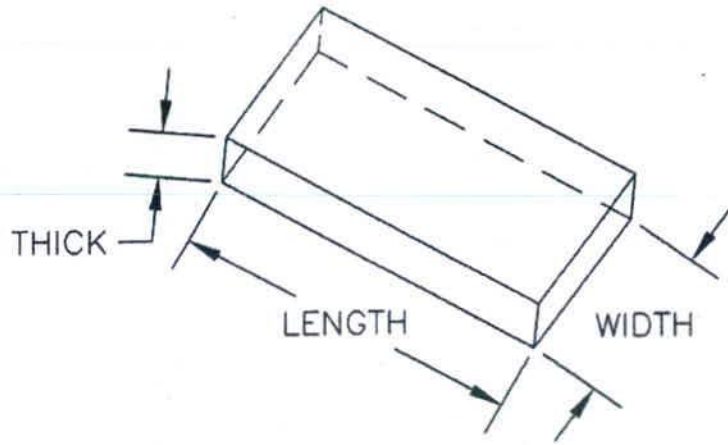
U 07-08-24



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31386

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31 555051 985482 01

A.M. Castle & Co.

A.M. CASTLE & Co. (Canada) Inc.

EXPEDIE 22 AOUL 2007

NO. REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPT-ACCT. VEND. SLS TERR. EXPEDIE PAR-SHIP VIA

3385

91037

200

40

TRUCK

MANITOULIN

ACHETEUR-PURCHASING AGENT

TELEPHONE

H/C TAXE

NO. COM ORD

REGION LIVRAISON-DEL ZONE

F.A.B.-F.O.B.

BILL

NO. P/ VILLE/ EMBALLAGE-B/L NUME

LINDA LACELLE

613 632-3336

9 0

1

C/C

PREPAID

VIVRE A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

INFORMATION CREDIT-CREDIT INFORMATION

R2C SEE FRANCE STATUS

ROUTE

01*NL-08

31-NL-08

INSTRUCTIONS/LIVRAISON-DELIVERY

INQ-658568

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

2.0000 PLATE 7075-T7351 ALUM 6.25" X 6.00"

BLACK W/RED STRIPE

QTE/UNITE COM.-ORDERED

PCES/PO COM.-ORD.

POIDS COM.-WT. ORDE

60 PCS PCS

4

BALLOTS-BUNDLES

PCES/PO EXP. SHIP

POIDS EXP.-WT. SHIPPE

1 60

455

FORME-SHAPE

I.A.C.

685

CERTIFICATE OF CONFORMANCE

A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon.

A.M. Castle & Co. (Canada) Inc.

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.

INSTRUCTIONS

TOL: +.030"/-.000"

THICKNESS TOL.: +.030"/-.000"

GRAIN TO RUN ALONG 6.00"

PRIOR DIST/ORD: 01 985482

COULÉE INFO-HEAT INFO

QTE-QTY

337471

8

350441

32

29.08850F

INSTRUCTIONS (CONT'D.)

60x6.25" x 6.00"
C207108123

DESCRIPTION - ITEM 2

TERMS AND CONDITIONS
OF SALESEE DISCLAIMERS AND LIMITATIONS
ON THE REVERSE SIDE

INSTRUCTIONS

1 Box

COULÉE INFO-HEAT INFO

QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCES/PO COM.-ORD.

POIDS COM.-WT. ORDE

BALLOTS-BUNDLES

PCES/PO EXP. SHIP

POIDS EXP.-WT. SHIPPE

FORME-SHAPE

I.A.C.

DESCRIPTION - ITEM 3

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

QTE/UNITE COM.-ORDERED

PCES/PO COM.-ORD.

POIDS COM.-WT. ORDE

BALLOTS-BUNDLES

PCES/PO EXP. SHIP

POIDS EXP.-WT. SHIPPE

FORME-SHAPE

I.A.C.

NOM (LETTRE MOULEE)-NAME (PRINT ONLY)

RECU PAR-RECEIVED BY

DATE RECU-
DATE RECEIVED

INSTRUCTIONS (CONT'D.)

FEVILLE D'EMBALLAGE - PACKING SI

ALCAN
ROLLED PRODUCTSCERTIFIED TEST REPORT
RAVENSWOOD, WV 26164 USAA M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE A44806 1512 INCLUSION SERIAL#: 20070504A44806 PAGE 1 OF 2

CUSTOMER PURCHASE ORDER NO. & ITEM				ALCAN ORDER NO.	
01-84320				113-581187	
ALLOY	CLAD	TEMPER	GAUGE	WIDTH	LENGTH
7075	00	T7351	2.00000	48.500	144.500
ITEM ORDERED					
DIST. AEROSPACE/COMM.					
SPEC PLATE, SAWED MILL					
CUSTOMER SPECIFICATION					
AMS-QQ-A-250/12					
PART NUMBER			B/L NUMBER	DATE SHIPPED	
			A44800	05/06/07	
WEIGHT SHIPPED		NO. OF PIECES	GOVT. CONTRACT NO.		
2,920		2			

CERTIFICATION

"ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

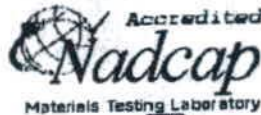
ALCAN ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26164 USA

LaDonna B. Smith - Quality Manager

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS									
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX								
350441	LT	2	***** T7351 71.0	72.6	60.1	61.8	***** 11.0	12.0	41.3	41.3								
<p>-----</p> <p>ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS</p> <p>-----</p> <p>MIL-STD-2154 100%SONIC TESTED MINUS DEAD ZONE CLASS A</p> <p>ALSO CONFORMS TO AMS 4078E, ASTM B209, BSS 7055 CL A</p> <p>ALSO CONFORMS TO BAC ASTM B594</p> <p>CASTLE METALS CORP.</p> <p>DATE RCVD <u>5/9/07</u></p> <p>IAC <u>6857</u></p> <p>APPROVED BY <u>[Signature]</u></p>																		
CHEMICAL COMPOSITION	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
	MIN.	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	EACH MAX	TOTAL MAX
	SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																		

ALCAN
ROLLED PRODUCTSCERTIFIED TEST REPORT
RAVENSWOOD, WV 26164 USA

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL
60131



A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL
60131

A M CASTLE 974503 1512 INCLUSION SERIAL#: 20070430974503 PAGE 1 OF 2

CUSTOMER PURCHASE ORDER NO. & ITEM 01-83993				ALCAN ORDER NO. 113-581105	
ALLOY 7075	CLAD. 00	TEMPER T7351	GUAGE 2.00000	WIDTH 48.500	LENGTH 144.500
ITEM ORDERED DIST. AEROSPACE/MILITARY SPEC PLATE, SAWED MILL					
CUSTOMER SPECIFICATION AMS-QQ-A-250/12					
PART NUMBER		B/L NUMBER 974500		DATE SHIPPED 04/30/07	
WEIGHT SHIPPED 5,720		NO. OF PIECES 4		GOVT. CONTRACT NO.	

CERTIFICATION
"ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

ALCAN ROLLED PRODUCTS
P.O. BOX 68

RAVENSWOOD, WV 26164 USA

LaDonna B. Smith
LaDonna B. Smith - Quality Manager

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND	IACS									
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX									
337471	LT	2	***** T7351 71.9	73.5	60.8	63.7	***** 11.5	11.5	40.5	41.6									
<p>ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS</p> <p>MIL-STD-2154 100%SONIC TESTED MINUS DEAD ZONE CLASS A</p> <p>ALSO CONFORMS TO AMS 4078E, ASTM B209-04 & ASTM B-594</p> <p>ALSO CONFORMS TO BSS 7055 CL A SONIC</p> <p>CASTLE METALS CORP DATE RCVD <u>5-4-07</u> IAC <u>6857</u> APPROVED <u>LC</u></p>																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	ACH	TOTAL
	SEE ACTUAL CHEMICAL COMPOSITION																		
ALUMINUM REMAINDER																			

05-04-'07 11:59 FROM-

T-557 P052/053 F-322

ALCAN
ROLLED PRODUCTSCERTIFIED TEST REPORT
RAVENSWOOD, WV 26164 USAA M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE 974503 1512 INCLUSION SERIAL#: 20070430974503 PAGE 2 OF 2

CUSTOMER PURCHASE ORDER NO. & ITEM				ALCAN ORDER NO.	
01-83993				113-581105	
ALLOY	CLAD	TEMPER	GUAGE	WIDTH	LENGTH
7075	00	T7351	2.00000	48.500	144.500
ITEM ORDERED					
DIST. AEROSPACE/MILITARY SPEC PLATE, SAWED MILL					
CUSTOMER SPECIFICATION					
AMS-QQ-A-250/12					
PART NUMBER		B/L NUMBER		DATE SHIPPED	
		974500		04/30/07	
WEIGHT SHIPPED		NO. OF PIECES		GOVT. CONTRACT NO.	
5,720		4			

CERTIFICATION

"ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

ALCAN ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26164 USA

LeDonna B. Smith - Quality Manager

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND	% IACS											
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX											
ACTUAL CHEMICAL COMPOSITION																					
337471 C SI= 0.06 FE= 0.18 CU= 1.40 MN= 0.05 MG= 2.55 CR= 0.19 ZN= 5.63 TI= 0.02 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																					
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																					
CHEMISTRY BY OES: ARKSPARK																					
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																					
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																					
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																					
"END OF CERTIFICATION"																					
CHEM COM	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS			
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.		
		SEE ACTUAL CHEMICAL COMPOSITION																			
ALUMINUM REMAINDER																					

ALCAN
ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164 USA

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE A44806 1512 INCLUSION SERIAL#: 20070504A44806 PAGE 2 CF 2

CUSTOMER PURCHASE ORDER NO. & ITEM				ALCAN ORDER NO.	
01-84320				113-581187	
ALLOY	CLAD.	TEMPER	GAUGE	WIDTH	LENGTH
7075	00	T7351	2.00000	48.500	144.500
ITEM ORDERED					
DIST. AEROSPACE/COMM. SPEC PLATE, SAWED MILL					
CUSTOMER SPECIFICATION					
AMS-QQ-A-250/12					
PART NUMBER		B/L NUMBER		DATE SHIPPED	
		A44800		05/06/07	
WEIGHT SHIPPED		NO. OF PIECES		GOVT. CONTRACT NO.	
2,920		2			

CERTIFICATION

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ALCAN ROLLED PRODUCTS

P.O. BOX 88

RAVENSWOOD, WV 26164 USA

LeDonna B. Smith - Quality Manager

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND %		IACS								
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX	MIN	MAX							
ACTUAL CHEMICAL COMPOSITION																			
350441 C SI= 0.06 FE= 0.16 CU= 1.42 MN= 0.01 MG= 2.52 CR= 0.19 ZN= 5.42 TI= 0.03 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																			
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																			
CHEMISTRY BY OES: ARKSPARK																			
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																			
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																			
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
"END OF CERTIFICATION"																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			

